

Work Order ID 61566

Page 1

Monday, August 30, 2010 11:23:53 AM

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 8/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *PL*Date: *10/8/30*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 005

*510109123***B61566**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Stop

Sequence ID/
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Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D27503- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",
deburr.4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade
fitting

5- Drill fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)
ONLY DRILL ONE SIDE OF FWD SADDLE HOLES USING DT81507- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE8- Clecko DT9642 and drill fwd saddle holes on second side, ensure proper
positioning.9-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting
location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up
holes for ground handling and detail C to 0.500" (8 holes per side)

10-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to

1 - JLC 10/08/10

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0.297"

11-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BE 10/08/31

12-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: ☐ M114877

BE 10/09/01

13-Grind welds flush as per Dwg D2750

SAD 10-09-01

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

100502

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

100502

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10-9-7

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

x1 - BE 10/09/07

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291batch: M115114 ☐☐☐exp. date: 11-1-30

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rodbatch: M114877

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

DP 10-9-7
DP 10-9-9
BE 10-9-14
BE 10-9-14

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

BE 10-9-14

12-Deburr holes

BE 10-9-14

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S1010214

Memo

0.00

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S1010214

Memo

0.00

(10)

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00 0.00	=) H	10/09/15		1	0		
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 11/114841 Memo START TIME: 11:20AM OVEN TEMPERATURE: 320°F FINISH TIME: 11:50AM	0.00 0.00	=) H	10/09/15		1	0		
210 QC Quality Control	QC3- Inspect Part Finish Memo Inspect for foreign object per QSI 024	0.00 0.00	BR	10-9-22		1	0		

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220  HandFinish Hand Finishing	HandFinishing Memo 1- Install inserts as per Dwg D2750	0.00 => M 0.00	10/09/22			1	0		
230  HandFinish Hand Finishing	HandFinishing Memo 1-Inspect for Foreign Objects 2-Spray inside of tube with "LPS-3" batch: N/A 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: M115114 EXP DATE: 11/05 4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: M114189 5-Coat all exposed fasteners with "LPS Procyon" batch: M114596	0.00 => M 0.00	10/09/22			1	0		

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/30/22



250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/9/22

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/30/22



*****ensure antiseize is on AN8C21A bolts*****

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270



Packaging

Packaging

Doc 70

0.00

Rev H

0.00

Memo

Package as per PPP D350-636-011

10/10/27 (L)

280



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/09/27

MF 10-9-27

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Picklist Print

Monday, August 30, 2010 11:23:59 AM

Page 1

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Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verified by:EC IPP Rev:P 10.06.22
 revise seq110 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2594-3 O-Ring, 205 Skidtube		Manufactured	No			230	Each	211.0000	8	8		10/09/22	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP				211					
				55546				19					
				58191				12					
				59358				180					
D2744 Cap		Manufactured	No			110	Each	27.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				27					
				59198				27					
D2600-3-BENT Extrusion Bent		Manufactured	No			110	Each	9.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				9					
				59410				9					

B61633 ①

10-8-31

W/O:		WORK ORDER CHANGES					
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Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 211.0000 8 8



Crossbolt Spacer

Location	Loc Qty	Loc Code
LG	211	
50281	10	
57953	2	
59111	199	

D2739 Manufactured No 160 Each 2.0000 1 1



350 I Beam

Location	Loc Qty	Loc Code
LG	2	
61256	2	

D3490-3 Manufactured No 160 Each 47.0000 4 4



Cross Bolt Spacer

Location	Loc Qty	Loc Code
LG	47	
60294	10	
61218	37	

D3490-1 Manufactured No 160 Each 85.0000 4 4



Cross Bolt Spacer

Location	Loc Qty	Loc Code
LG	85	
59424	3	
61217	82	

BE 10/9/14

DP 9-10-9

BE 10/9/14

BE 10/9/14

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Shop Packet Print

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Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

220

Each

5,418.000

38

38



Insert



HL 10/09/22

Location

Loc Qty

Loc Code

PK011

5418

110768

5418

D3492-041

Manufactured

No

230

Each

57.0000

8

8



Plug Assembly



HL 10/09/22

Location

Loc Qty

Loc Code

FP013

57

59114

1

61311

56

D3793-3

Manufactured

No

230

Each

14.0000

1

1



Wearshoe



HL 10/09/22

Location

Loc Qty

Loc Code

FP18

13

59631

1

61258

12

FP19

1

57947

1

AN8C35A

Purchased

No

230

Each

41.0000

1

1



BOLT



HL 10/09/22

Location

Loc Qty

Loc Code

FP

1

110847

1

ST346

40

114442

15

115188

25

VI

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Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230 Each

15.0000

1 1



Wearshoe



10/09/22

Location

Loc Qty

Loc Code

FP18

15

59151

1

59630

2

61244

12

D3488-041

Manufactured No

230 Each

10.0000

1 1



Blade Fitting Assembly, LH



10/09/22

Location

Loc Qty

Loc Code

FP

7

53915

7

FP007

3

56052

3

D3794-3

Manufactured No

230 Each

12.0000

1 1



Gasket



10/09/22

Location

Loc Qty

Loc Code

FP10

1

60826

1

FP18

11

56066

10

59153

1

Monday, August 30, 2010 11:23:59 AM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, August 30, 2010 11:23:59 AM

Work Order ID: 61566

Parent Item: D350-636-011


Parent Item Name: Skidtube LH

Start Date: 8/30/2010

Required Date: 9/6/2010


Start Qty: 1.00

Required Qty: 1.00

AN6C44A Purchased No 230 Each 129.0000 4 4

 BOLT


Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST344	127	
111649	2	
114653	1	
114941	75	
115030	49	

10/09/22

MS21083C8 Purchased No 230 Each 30.0000 1 1

 NUT

Location	Loc Qty	Loc Code
ST303	30	
113845	7	
114934	23	

10/09/22

D3536-25 Manufactured No 230 Each 11.0000 1 1

 Gasket

Location	Loc Qty	Loc Code
FP12	11	
59625	11	

1361707

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 61566

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3631-1 Manufactured No

230

Each

475.0000

8

8



Washer



HL 10/09/22

Location

Loc Qty

Loc Code

ST072

201

60755

201

X8

ST076

274

52693

206

54388

68

D3791-1 Manufactured No

230

Each

9.0000

1

1



Wearplate



HL 10/09/22

Location

Loc Qty

Loc Code

FP17

9

58573

8

X1

59626

1

AN960C10L Purchased No

230

Each

155.0000

38

38



washer



HL 10/09/22

Location

Loc Qty

Loc Code

ST245

155

107534

29

109545

54

111548

72

M115698

X38

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Monday, August 30, 2010 11:23:59 AM

Page 7

Work Order ID: 61566

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

173.0000

8

8



Bushing



JH 10/09/22

Location

Loc Qty

Loc Code

ST023

173

52311

5

59112

68

61203

100

x8

AN3C5A

Purchased No

230

Each

1,072.000

34

34



Bolt



JH 10/09/22

Location

Loc Qty

Loc Code

ST350

1062

114330

11

115015

251

15108

300

115316

300

115371

100

115422

100

ST351

10

113121

10

x34

D3537-1

Manufactured No

230

Each

8.0000

3

3



Wearpad



JH 10/09/22

Location

Loc Qty

Loc Code

FP

1

55465

1

FP017

48

FP17

7

57713

3

60491

4

1361640

x3

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 8

Monday, August 30, 2010 11:23:59 AM

Work Order ID: 61566

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased No

230 Each

0.0000

1

1



WASHER * WAS1149C08332R / M114915

D3492-043

Manufactured No

230 Each

23.0000

8

8



Plug Assembly

vl 10/09/22

vl 10/09/22

Location

Loc Qty

Loc Code

FP

2

B61503

X 8

54682

2

FP013

21

59117

1

59190

4

61207

16

AN3C6A

Purchased No

230 Each

353.0000

4

4



BOLT

vl 10/09/22

Location

Loc Qty

Loc Code

ST351

353

11982

353

vs

NAS1611-013

Purchased No

230 Each

103.0000

8

8



O-RING

vl 10/09/22

Location

Loc Qty

Loc Code

FP

103

114451

3

115460

100

M 115589

vs

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Page 8

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, August 30, 2010 11:23:59 AM

Page 9

Work Order ID: 61566

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-25	Manufactured	No	230	Each	10.0000	1	1
							<u>HL 10/09/22</u>
Wearshoe							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
D3794-1	Manufactured	No	FP18	10	B61706	1	<u>XL</u>
			59623	10		1	<u>HL 10/09/22</u>
Gasket							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
MS21043-6	Purchased	No	FP010	7		4	<u>YL</u>
			57942	7		4	<u>HL 10/09/22</u>
NUT							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
D3493-1	Manufactured	No	ST301	678		2	<u>YL</u>
			112314	678		2	<u>10/9/22 sf</u>
Washer							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST065	34			
			59127	4			
			60873	30			<u>Z</u>

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 10

Monday, August 30, 2010 11:23:59 AM

Work Order ID: 61566

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

MS21083C8
NUT

Purchased No

260 Each

30.0000

1

2

Location

Loc Qty

Loc Code

ST303

30

113845

7

114934

23

Purchased No

260 Each

43.0000

2

2

AN8C21A
BOLT

Location

Loc Qty

Loc Code

ST345

43

113558

3

114653

40

Purchased No

260 Each

0.0000

1

2

AN960C816L
WASHER

D3672-1

Manufactured No

230 Each

921.0000

4

4

Phenolic Washer

Location

Loc Qty

Loc Code

ST077

921

42329

150

52505

771

Manufactured No

260 Each

14.0000

1

1

D2741
Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

14

57949

14

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 61566

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

260 Each

19.0000 2



Spacer



10/9/2010 SP

Location

Loc Qty

Loc Code

ST068

19

60510

19

D3672-13

Purchased No

260 Each

828.0000 2



Phenolic Washer



10/9/2010 SP

Location

Loc Qty

Loc Code

ST077

828

54363

828

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61366
B810-8-80

RELEASED
6-27-72

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (2) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PO RAT	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.	ST	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

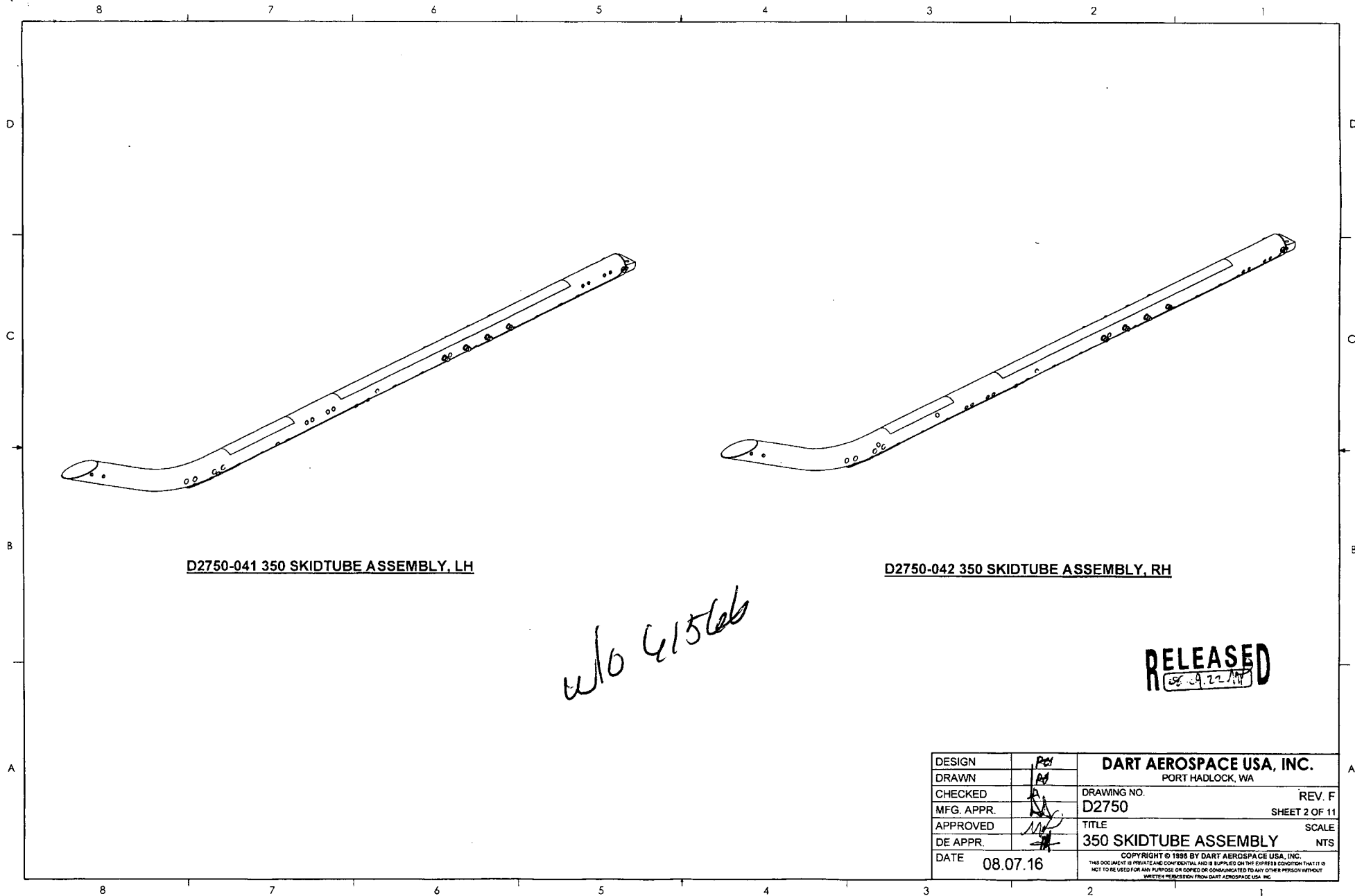
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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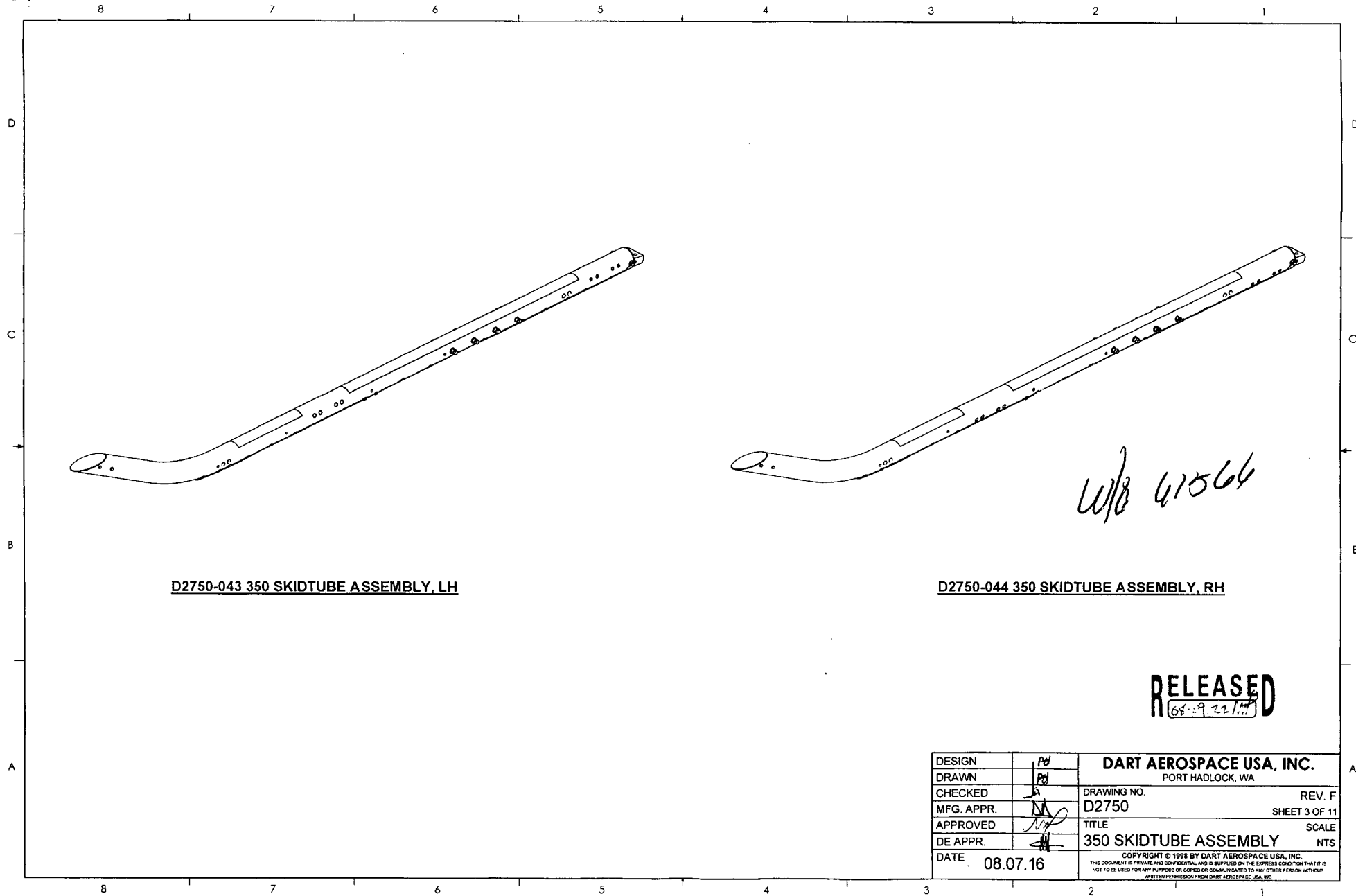
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/B 41566

RELEASED
68-9-22-111

DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO. D2750	REV. F
MFG. APPR.	NA	SHEET 3 OF 11	
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

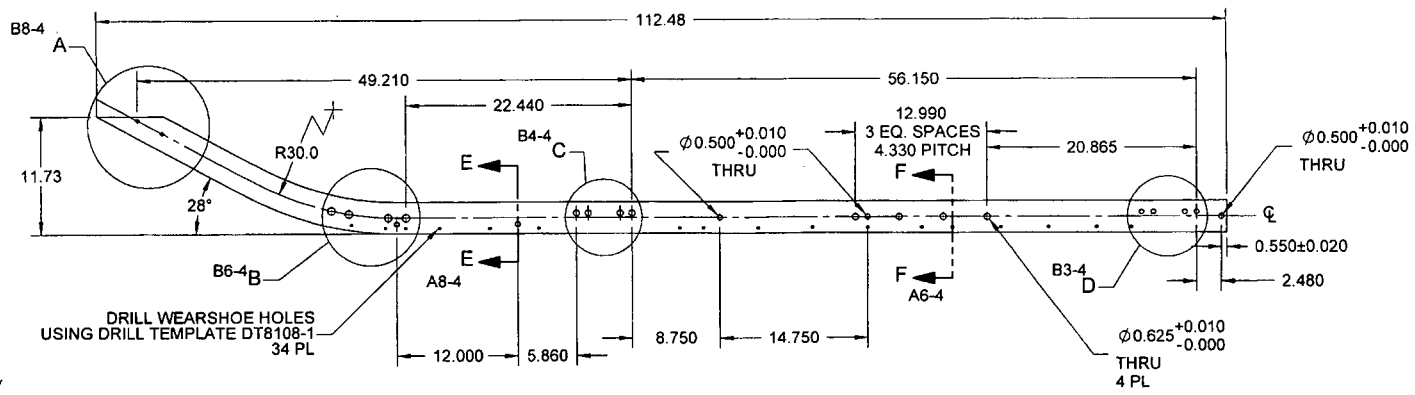
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

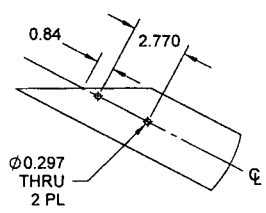
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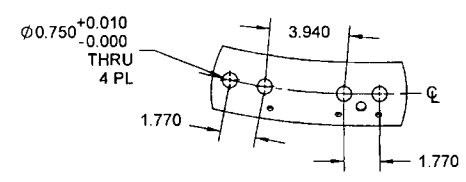
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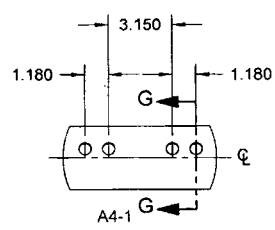
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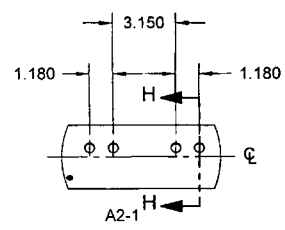
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SCALE 2X



DETAIL B
SCALE 2X

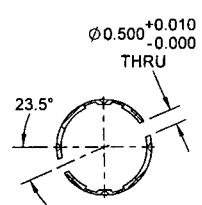


DETAIL C
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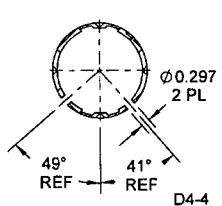


DETAIL D
SCALE 2X

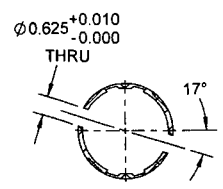
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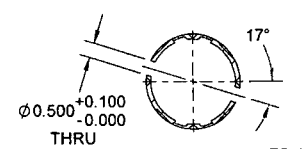
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SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

RELEASED
02 09 12 1997

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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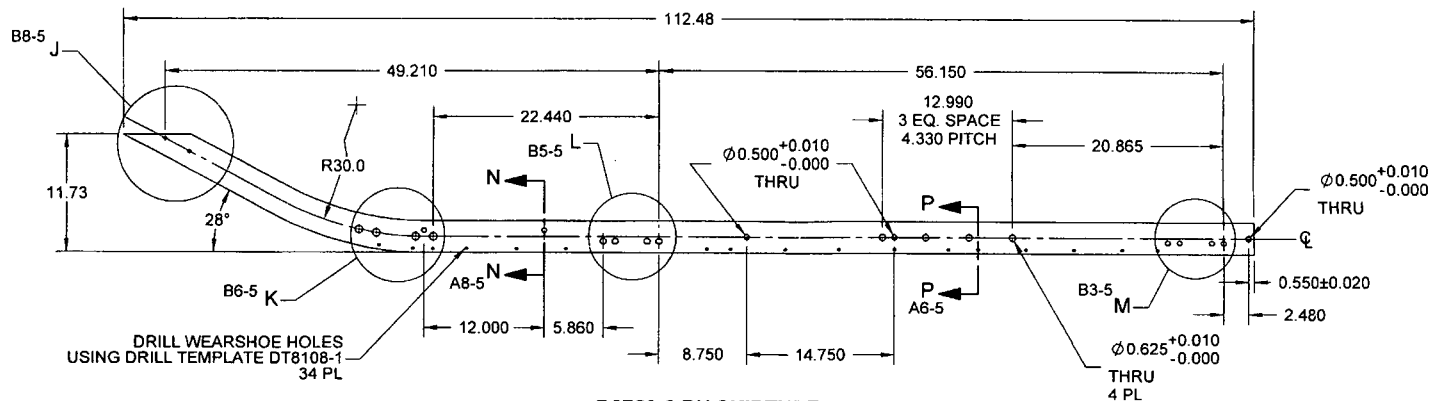
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

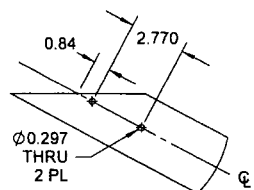
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

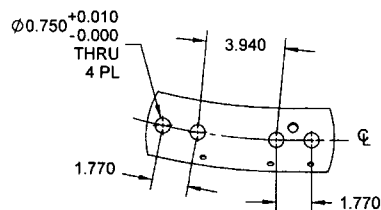
NOTE: Date & initial all entries



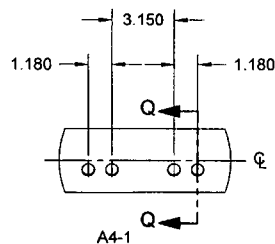
D2750-2 RH SKIDTUBE



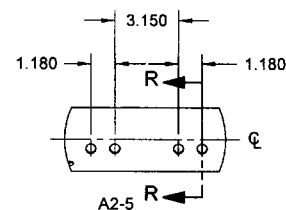
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SCALE 2X



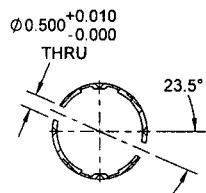
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SCALE 2X



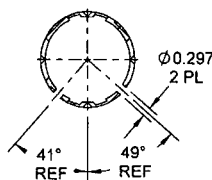
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SCALE 2X



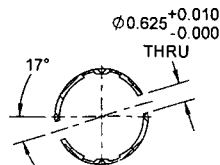
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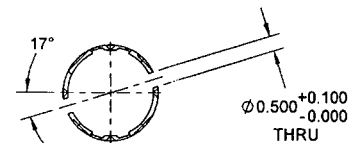
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

DESIGN	DART AEROSPACE USA, INC.
DRAWN	PORT HADLOCK, WA
CHECKED	DRAWING NO. D2750
MFG. APPR.	REV. F
APPROVED	SHEET 5 OF 11
DE APPR.	TITLE 350 SKIDTUBE ASSEMBLY
DATE 08.07.16	SCALE NTS

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WLB 61344

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

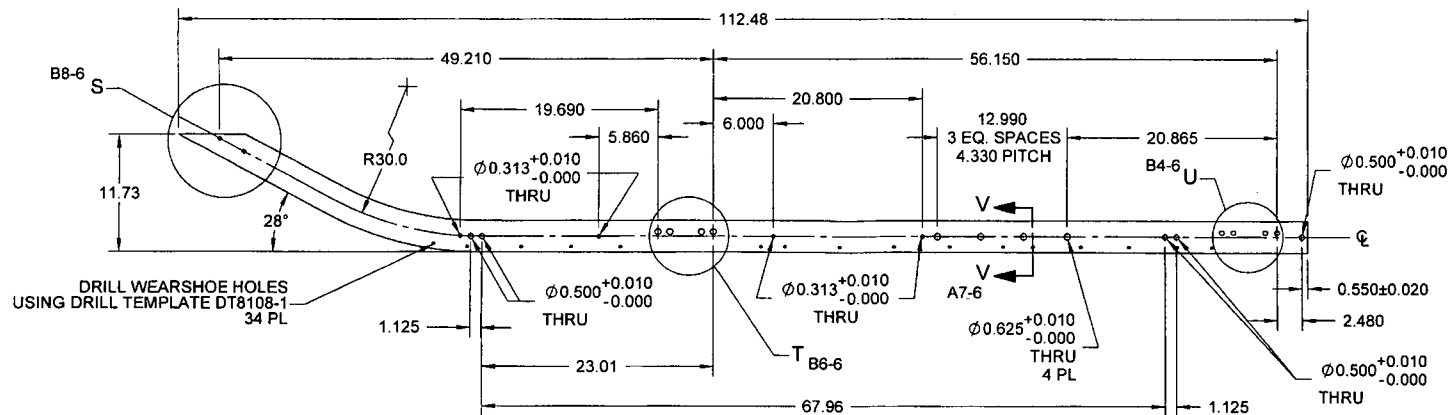
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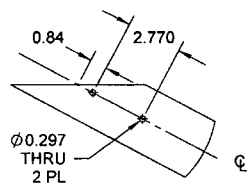
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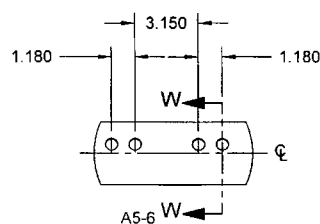
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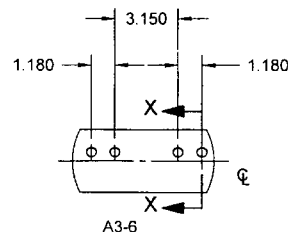
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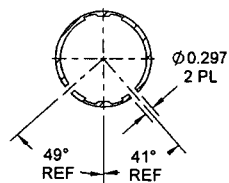
D8-6
SCALE 2X



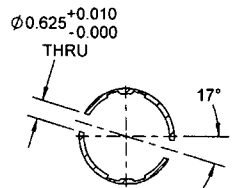
C5-6
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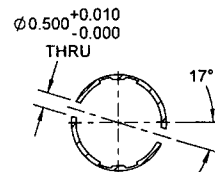
D3-6
SCALE 2X



C4-6
SCALE 3X, 17 PL



B6-6
SCALE 3X, 4 PL



B4-6
SCALE 3X, 4 PL

W/O 61566

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8-12-11

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MFG. APPR.		D2750	SHEET 6 OF 11
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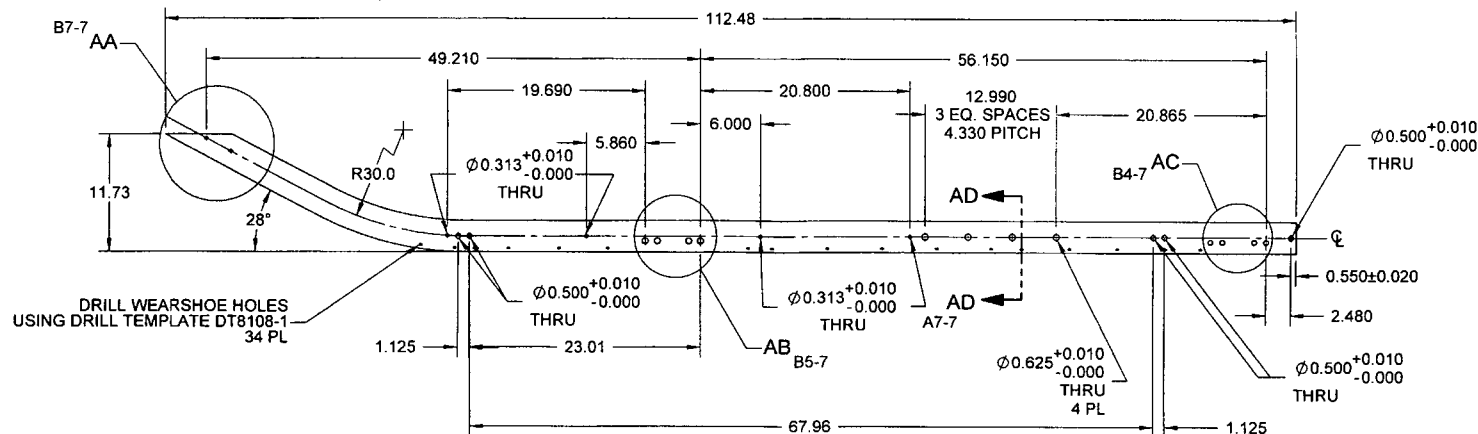
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

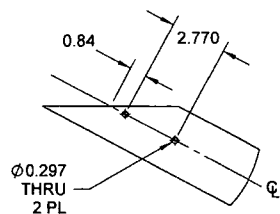
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

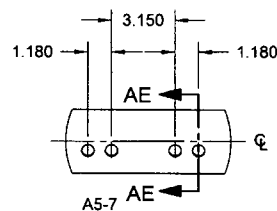
NOTE: Date & initial all entries



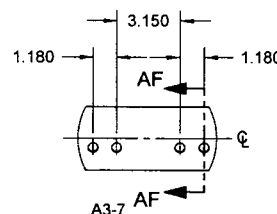
D2750-4 RH SKIDTUBE



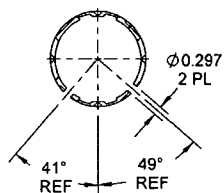
DETAIL AA
SCALE 2X



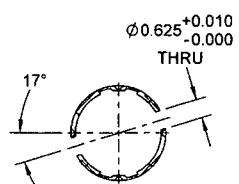
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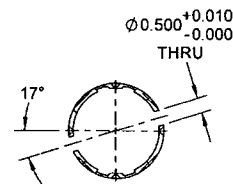
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

WLO 61566

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CHECKED	<i>PE</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>PE</i>	D2750	SHEET 7 OF 11
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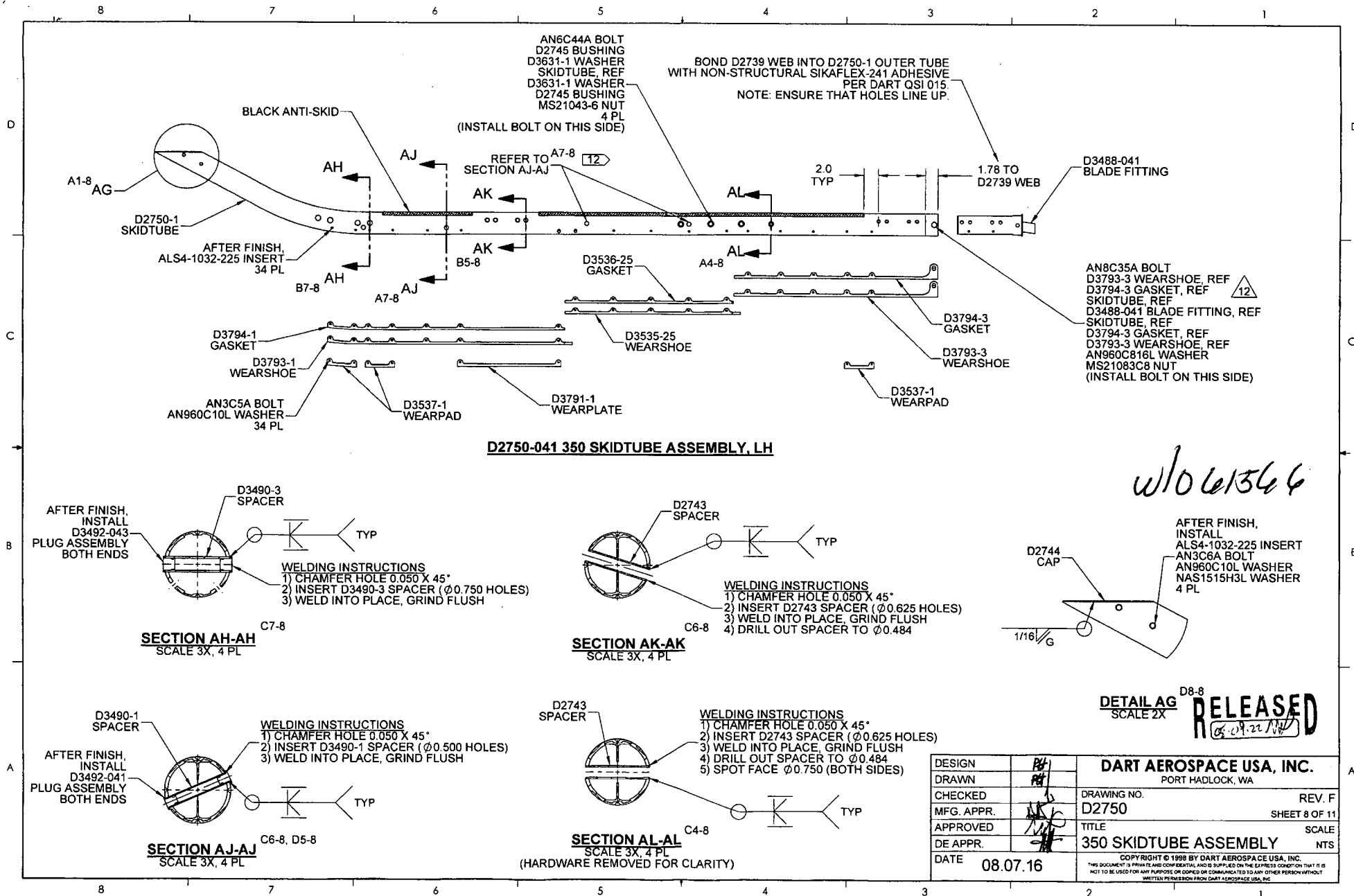
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NOTE: Date & initial all entries



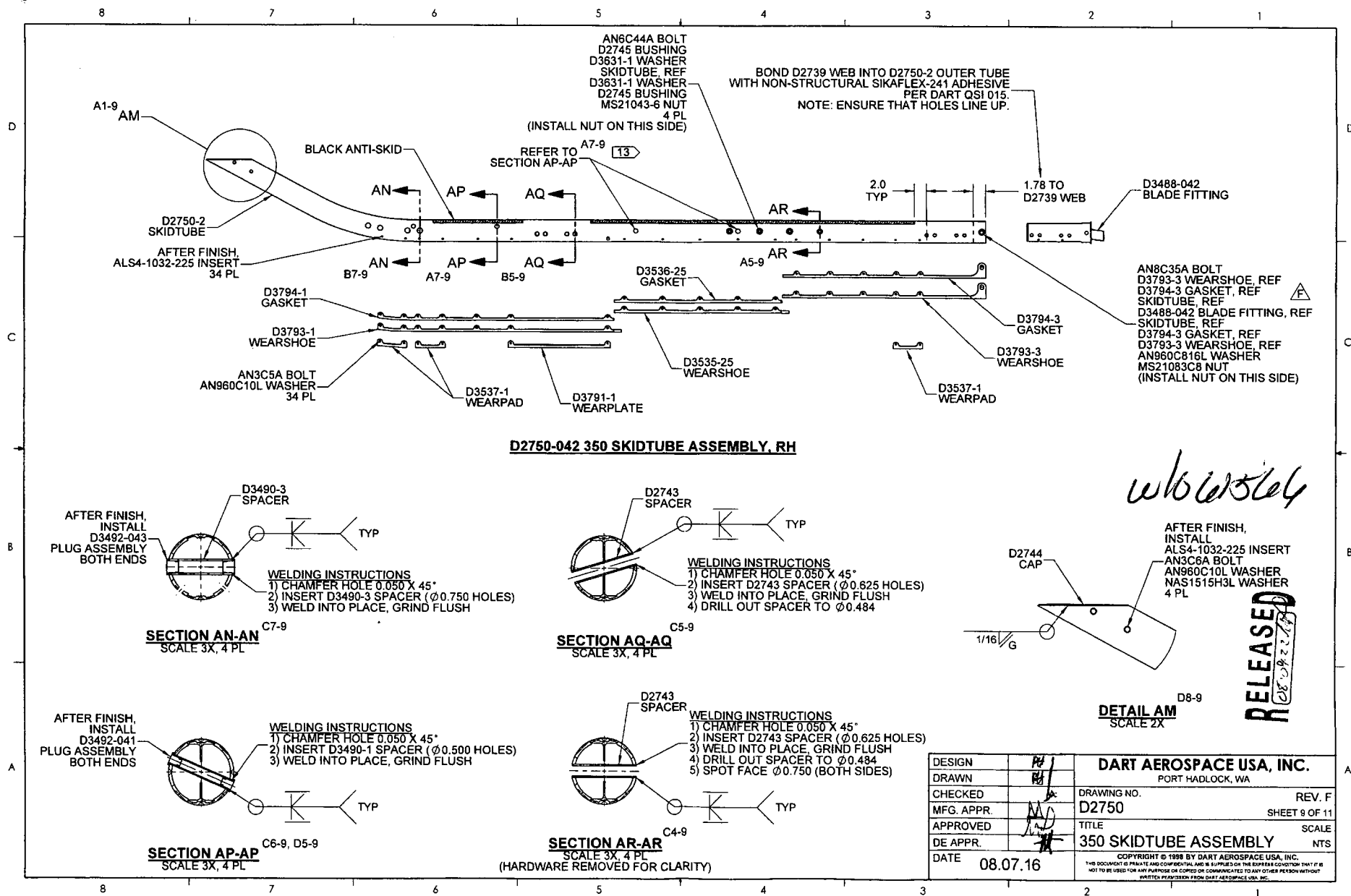
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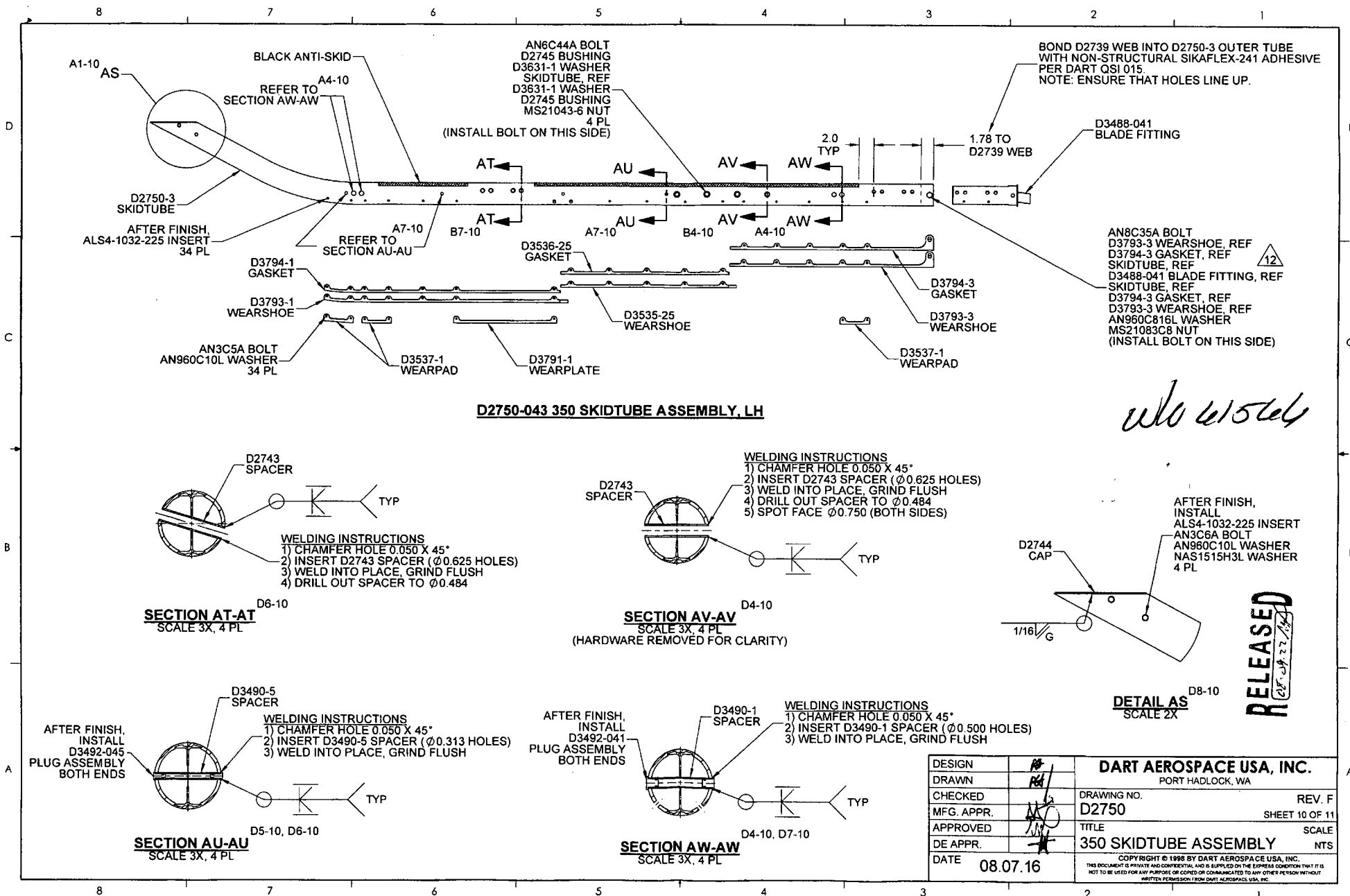
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MFG. APPR.		D2750	SHEET 10 OF 11
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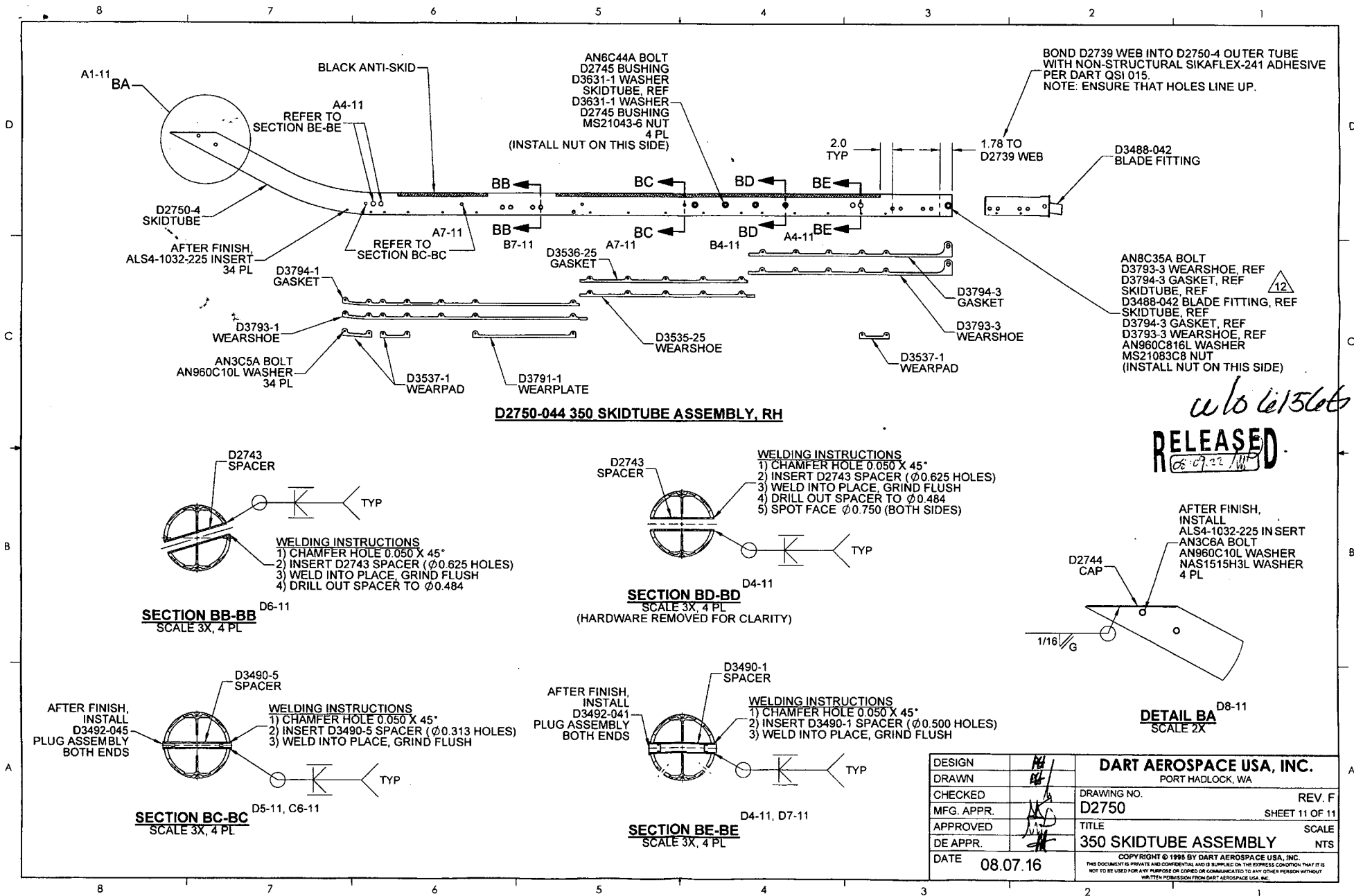
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 236

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 60988
Part number: D350-636-012
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 10.08.12

Welder [Signature] Date of Test Coupon 10.08.12

The above named individual is qualified in accordance with AWS D17.1.2001 to weld